

Date: Wednesday, 9/20/2006 3:16:30 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: A119 STEP WELDMENT LH		
Job Number	: 28654		Part Number	: D3043041		
Estimate Number	: 10122		Drawing Number	: D3043 REV A		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 9/20/2006	S.O. No. : N/A	Drawing Revision	: A		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 9/25/2006 Qty: 1 Um: Each		
Previous Run	: 26197A					
Written By	: <u>KJ</u> 06.09.20					
Checked & Approved By						
Comment	: Est Rev :A New Issue JLM 05-11-01					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D2622120C	Extrusion	
<b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: D2622-120 extrusion Batch: <u>327077</u> <span style="float: right;">LE. 06.09.21</span>			
2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	
<b>Comment:</b> LARGE FABRICATION RESOURCE 1 1-Cut D2622-120 extrusion to 120.00" long as per Dwg D3043 using cutting table setup DT8185-G <span style="float: right;">LE. 06.09.21</span> 2-Deburr and bevel ends for welding <span style="float: right;">LE. 06.09.21</span>			
3.0	QC5	INSPECT WORK TO CURRENT STEP	
<b>Comment:</b> INSPECT WORK TO CURRENT STEP <span style="float: right;">PD 06-09-21 (1)</span>			
4.0	D2734	206 Step Endplate	
<b>Comment:</b> Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Pick: Qty Part Number Description Batch 2 D2734 End Cap <u>327281</u> <span style="float: right;">LE. 06.09.21</span>			
5.0	D30401	Mounting Lug	
<b>Comment:</b> Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Pick: Qty Part Number Description Batch 2 D3040-1 Mounting Lug <u>324405</u> <span style="float: right;">LE. 06.09.21</span>			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

## Process Sheet

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Drawing Name: A119 STEP WELDMENT LH

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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 D30403 Mounting Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D3040-3	Mounting Lug	<i>B24406</i>

*SE. 06-09-21*

7.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld 1 End Cap & Mounting Lugs as per QSI 004 & Dwg D3043 Using DT8802  
 AR AL ROD Batch: *m19612 m15689*

*SE. 06-09-21*

2-Grind Fwd End Cap weld flush

*SE. 06-09-21*

8.0 QC5/9 WELD INSPECTION



Comment: WELD INSPECTION

*SE. 06-09-21 (1)*

9.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Chemical Conversion Coat as per QSI 005 4.1

*FF 06-09-21*
*2-Powder Coat White (Ref. 4.3.5.2) as per QSI 005 4.3*

10.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-1-Weld 1 End Cap as per QSI 004 & Dwg D3043  
 AR AL ROD Batch: *m15689*

*SE. 06-09-22*

2-Inspect for foreign object as per QSI 024

*SE. 06-09-22*

3-Grind Fwd End Cap weld flush

*SE. 06-09-22*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA: 170 Date: 06/08/26  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: A119 STEP WELDMENT LH

Job Number: 28654

Part Number: D3043041

Job Number:



Seq. #:	Machine Or Operation:	Description :
11.0	QC5/9	WELD INSPECTION
	Comment: WELD INSPECTION	1106/09/22 ①
12.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
	Comment: HAND FINISHING RESOURCE #1	FC 06 09 22 ①
13.0	POWDER COATING	POWDER COATING
	Comment: POWDER COATING	FC 06 09 22 ①
	Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3	
14.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
	Comment: HAND FINISHING RESOURCE #1	
15.0	QC3	1-Wing Walk as per Dwg D3043 and QSI 005 4.4
		a.m 06-09-23 ①
	Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION	
16.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1	
	Identify and Stock	
	Location: _____	
17.0	QC21	FINAL INSPECTION/W/O RELEASE
	Comment: FINAL INSPECTION/W/O RELEASE	06/09/25 ①
	Job Completion	
		06-09-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	REV. A
		D3043	SHEET 1 OF 2
DATE		TITLE	SCALE
01.06.28		A119 STEP WELDMENT	NTS
A	01.06.28	NEW ISSUE	

**PARTS LIST:**

Qty -041	Qty -043	Part Number	Description
X		D3043-041	STEP WELDMENT, LH
	X	D3043-042	STEP WELDMENT, RH
1	1	D2622-120	STEP EXTRUSION
2	2	D3040-1	MOUNTING LUG
2	2	D3040-3	MOUNTING LUG
2	2	D2734	ENDPLATE

**NOTES:**

- 1) MANUFACTURE FROM D2622-120 EXTRUSION
- 2) WELD PER DART QSI 004. ALL WELDS SHOULD BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004
- 3) FINISH: ACID ETCH & ALODINE ASSEMBLY PER DART QSI 005 4.1  
POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT TOP SURFACE OF STEP TO BOTTOM OF TOP  
RADIUS PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**RELEASED**  
01.07.05

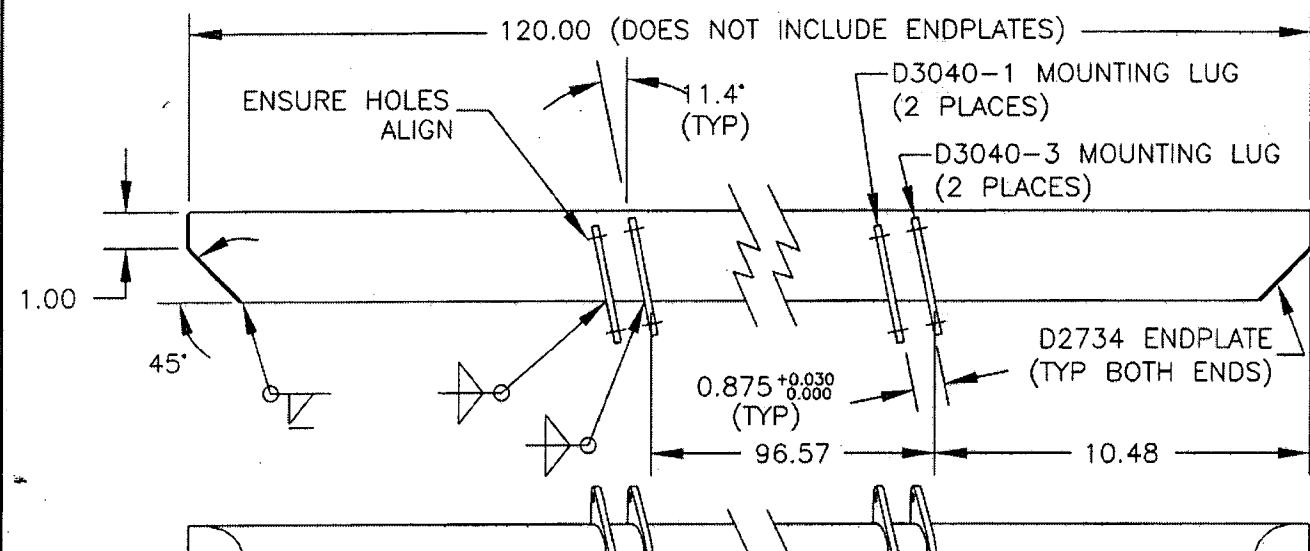
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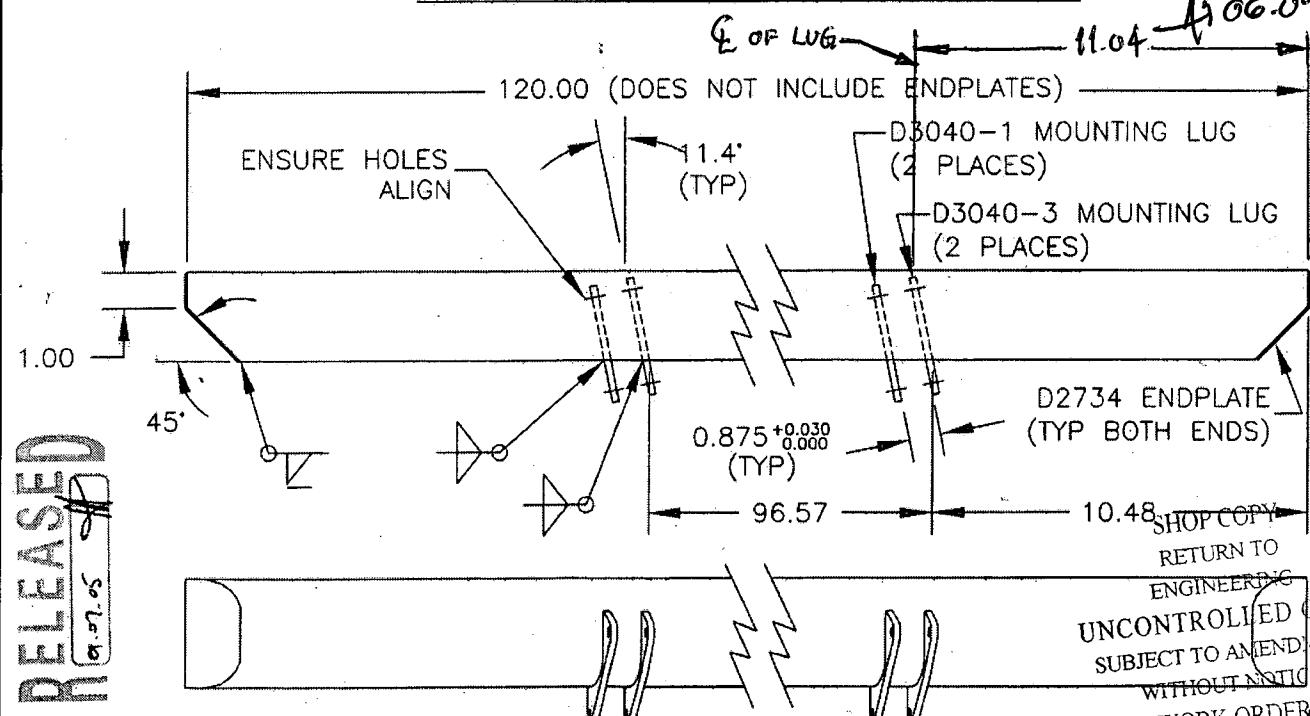
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DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO. D3043
DATE		REV. A SHEET 2 OF 2
01.06.28		TITLE A119 STEP WELDMENT
A	01.06.28	SCALE 1:5
		NEW ISSUE



VIEW A-A: D3043-041 LH STEP WELDMENT



VIEW A-A: D3043-042 RH STEP WELDMENT

WORK ORDER  
NO 28654

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